

# Work Order ID 57921

April 20, 2010 10:04:25 AM

Page 1

Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 20/04/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820" Batch: 45800

H.A 10/04/29

40

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235-1-Identify as D3235-1-3-Deburr

H.A 10/04/29

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

H.A 10/04/29  
R 10.5.01

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SB 10/05/03

40

1

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

40

SB 10-5-3

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/05/03

40

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 57921

April 20, 2010 10:04:25 AM



Page 3

Item ID: D3235-1

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Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 20/04/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



1114207

Powdercoat

Memo

0.00

⇒ 261 10/05/04

40

9

Powder Coating

START TIME:

7:30 AM

OVEN TEMPERATURE:

8:00 AM

FINISH TIME:

320°F

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

410

BR 10-5-4.

Quality Control

180

Identify as per dwg & Stock Location:

0.00



471

Packaging

Memo

0.00

10-5-21

SP402

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 57921**

April 20, 2010 10:04:25 AM



Page 4

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Start Date: 20/04/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *[Signature]*  
CMF  
10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

April 20, 2010 10:04:29 AM

Page 1

Work Order ID: 57921

Parent Item: D3235-1

Parent Item Name: Mounting Lug



Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Start Date: 20/04/2010

Required Date: 29/04/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1P 		Purchased	No			100	Each	0.0000	40.0000			
lug D2423 		Manufactured	No			110	f	518.7499	2.8758			
Lug Extrusion												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT06

518.7499

43722

180

45800

338.7499

2 8758

B.A 10/04/29

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 57921
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D3235-1
<b>Inspection Dwg:</b> D3235	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.447	✓			
0.306	+/-0.010	0.303	✓			
1.85	+/-0.030	1.849	✓			
R1.20	+/-0.010	R1.205	✓			
R0.125	+/-0.010	R0.125	✓			
0.400	+/-0.010	0.400	✓			
0.735	+/-0.030					
Ø0.505	+0.005/-0.000	Ø 0.507	✓			
R0.38	+/-0.030	R0.380	✓			
3.700	+/-0.005	3.700	✓			
0.375	+/-0.010	0.375	✓			
0.750	+/-0.010	0.751	✓			
Ø0.257	+0.005/-0.000	Ø 0.260	✓			
R0.380	+/-0.030	R0.380	✓			

<b>Measured by:</b> b.A	<b>Audited by:</b> S.B	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/04/29	<b>Date:</b> 10/05/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

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